

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006572**Date Inspected:** 02-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

QA Inspector received notification to perform visual verification inspection of ZPMC QC accepted OBG interior platform and railing miscellaneous welded assemblies prior to blast cleaning. QA Inspector randomly performed visual inspection of welds and base material for the following items.

SA 202 Platform

SA 203 Platform Railing

SA 205 Platform

SA 206 Platform Railing

QA Inspector observed that WT attachment brackets on platforms SA202 and SA206 were only tack welded. Segment drawings required these WT brackets to be welded with an 8 mm fillet weld. ZPMC Quality Control (QC) Inspector Wu Zhi Feng informed QA Inspector that the brackets will be welded at time of installation in the Cross Beam (CB) assembly. The brackets need to be fit to CB for proper installation then the WT brackets will be welded to the platform. QA Inspector informed ZPMC QC Inspector that all other welds and base material appear to be in accordance with AWS D1.5 (02) and the contract documents except WT brackets noted above.

QA Inspector continued OBG Segment tracking documentation control for sub assembly green tagging, segment

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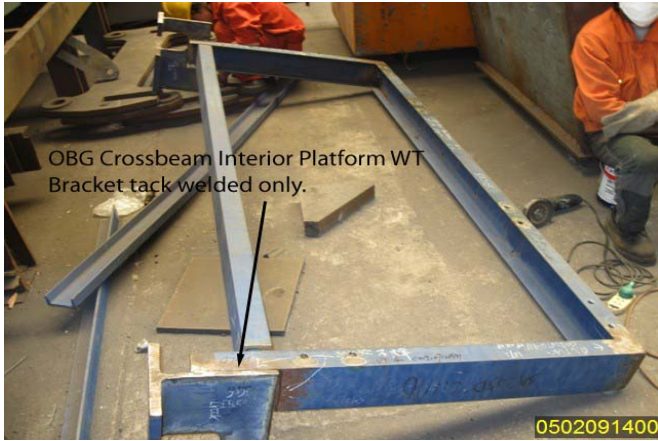
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weld repairs after blast cleaning, and segment splicing fit up dimensions taken.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

Summary of Conversations:

Conversations noted in items observed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
